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D3286-1
Job Sheet 172813



Part No: D3286-1

Job Qty: 30 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No:

Due Date: 3/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP A 04.07.14 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-06-16 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		3/10/18	0.00	0.00	Start Up Waterjet		SC 18/03/09
100	Waterjet	30 pcs		3/10/18	0.00	1.17	Waterjet1		SC 18/03/09
120	QC	30 pcs		3/10/18	0.00	0.00	QC8		38
130	Brake NC	30 pcs		3/12/18	0.01	0.53	Brake NC 1		9-89 SD
140	QC	30 pcs		3/12/18	0.00	0.00	QC5		18-3-16
150	Packaging	30 pcs		3/12/18	0.00	0.00	Packaging3		MAR 19 2018
160	QC21-SA	30 Ea		3/12/18	0.00	0.00	QC21		L6001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	2.2470 sf (.0749 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S11GA	2	3	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	5.374inches ± 0.010	5.384 5.364	5,377	
2	Doubler	3.974inches ± 0.010	3.984 3.964	3,973	
3	Doubler	2.000inches ± 0.010	2.010 1.990	1,997	
4	Doubler	1.000inches ± 0.010	1.010 0.990	1,006	
5	Doubler	0.700inches ± 0.010	0.710 0.690	0,705	
6	Doubler	0.188inches + 0.005 - 0.001	0.193 0.187	0,191	
7	Doubler	0.125inches ± 0.010	0.135 0.115	0,115	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____			
Description Work Order Deviation					

Container No: S049486
 Part: D3286-1
 Job No: 172813
 Serial No/Batch: S049486
 Revision: _____
 Inspector: _____
 Date: 03/09/18

Root Cause			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	
Design ☐	Operator ☐	Bending ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Conce ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	
Tribal Knowledge ☐	Rushing ☐	Countersink ☐	
LOA ☐	Product Improvement ☐	Cut Too Short ☐	
Substation ☐	Process Improvement ☐	Instructions Incomplete/Unclear ☐	
Past Expiry Date ☐	Manufacturing Process ☐	Drill Holes ☐	
Misidentified ☐	Past Due ☐	OTHER : _____	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					